

5/24

SPUT

6

DART AEROSPACE LTD	Work Order:	23329 A
Description: Hi-Step Leg Assembly	Part Number:	D2582
Dwg: D2582 Rev. A; D2322 Rev. C; D2279 Rev. D	Qty:	202
Page 1 of 2		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller (minimum lots of 5) & RF 02.10.22	EP	05.05.20	20
2	MV	Cut blanks: (6.520" x 4.500") +/- 0.010" (grain along 4.500") Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick (M2024T3S.040) Identify as D2322 Batch: M17347	En	05/06/16	20
3	MV	Cut blanks: (4.70" x 4.50") -0.00/+0.020" (grain along 4.50") Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick (M2024T3S.040) Identify as D2279 Batch: M17347	En	05/06/16	20
4	MV	Cut blanks: (16.61" x 8.51") +.000/-0.020" (grain along 8.51") for each leg Material: 5052-H32 sheet (QQ-A-250/8) 0.080" Thick (M5052H32S.080) Identify as D2278 Batch: M17390 (Note: make two legs per assembly)	En	05/06/16	20
5	MV	Cut blank: (3.400") +/-0.020" Material: 6061-T6 (QQ-A-250/8) 0.25" Thick (M6061T6B0.250x1.000) Identify as D2280 Batch: M11853 (Note: make two spacers per assembly)	En	05/06/16	20
6	MV	Machine as per folio D2322, use stack of 15	EP	05/06/17	29
7	MV	Deburr to take measurement	EP	05/06/17	29
8	QC2	Inspect parts as they come off the CNC machine	EP	05/06/17	29
9	QC8	Second inspection	EP	05/06/17	29
10	MV	Machine as per folio D2279, use stack of 15	EP	05/06/17	29
11	MV	Deburr to take measurement	EP	05/06/17	30
12	QC2	Inspect parts as they come off the CNC machine	EP	05/06/17	30
13	QC8	Second inspection	EP	05/06/17	30
14	MV	Machine as per folio D2278, use stack of 10	EP	05/06/16	40
15	MV	Deburr to take measurement	EP	05/06/16	40
16	QC2	Inspect parts as they come off the CNC machine	EP	05/06/16	40
17	QC8	Second inspection	EP	05/06/17	40
18	MV	Machine per folio D2280 and Dwg D2280	EP	05/06/17	40
19	QC2	Inspect parts as they come off the CNC machine	EP	05/06/17	40
20	MV	Tumble. Deburr any rough edges after tumbling.	EP	05/06/17	40

RELEASED
02/10/22 RF






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Page 2 of 2		

Step	Location	Procedure	By	Date	Qty																												
21	QC8	Second inspection	me	05/06/17	40																												
22	GA	Deburr D2322, D2279 and D2278 stack	SB	05/06/20	2																												
23	GB	Bend D2322 and D2279 per Dwg D2322 and D2279	SB	05/06/20	2																												
24	QC5	Inspect work to Step 23	J	05-06-20	2																												
25	FP	Chemical conversion as per QSI 005 D2278, D2279, D2280, D2322	MM	05-06-20	2																												
26	GA	Assemble as per Dwg D2582 and Identify as D2582 Assembly <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D2278</td><td>Leg</td><td>B 23329</td></tr><tr><td>1</td><td>D2279</td><td>Spacer</td><td>B 23329</td></tr><tr><td>2</td><td>D2280</td><td>Spacer</td><td>B 23329</td></tr><tr><td>1</td><td>D2322</td><td>Spacer</td><td>B 23329</td></tr><tr><td>22</td><td>MS20470AD4-4</td><td>Rivet</td><td>M 15829</td></tr><tr><td>4</td><td>MS20470AD4-5</td><td>Rivet</td><td>M 15924</td></tr></table>	Qty	Part Number	Description	Batch	2	D2278	Leg	B 23329	1	D2279	Spacer	B 23329	2	D2280	Spacer	B 23329	1	D2322	Spacer	B 23329	22	MS20470AD4-4	Rivet	M 15829	4	MS20470AD4-5	Rivet	M 15924	SB	05/06/21	2
Qty	Part Number	Description	Batch																														
2	D2278	Leg	B 23329																														
1	D2279	Spacer	B 23329																														
2	D2280	Spacer	B 23329																														
1	D2322	Spacer	B 23329																														
22	MS20470AD4-4	Rivet	M 15829																														
4	MS20470AD4-5	Rivet	M 15924																														
27	QC5	Inspect work to Step 26	J	05-06-21	2																												
28	GA	Identify and Stock	J	05-06-21	2																												
29	AC	Cost / part 22.41	AF	05/06/26	2																												
30	DC	Close W/O 36.47 Inspect Level 21	AF	05/07/05	2																												

Rev	Date	Change	Revised By	Approved
A	96.07.08	New Issue		
B	99.02.10	Re-format	DM	
C	01.10.16	Added new rivet and new dwg (mpp2165)	SM	
D	02.05.14	Added rivet option	NG	
E	02.10.07	Re-format; Incorporated D2278, D2279, D2280, D2322	KJ RF	

RELEASED
06/10/22 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-06-20	23	1x D2279 scrap. cracked when holes were pressed.		Scrap and replace from B23327B stack	 05-06-20	 05-06-20	 05-06-20	 05-06-20

Part No: D2582 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 05/07/05

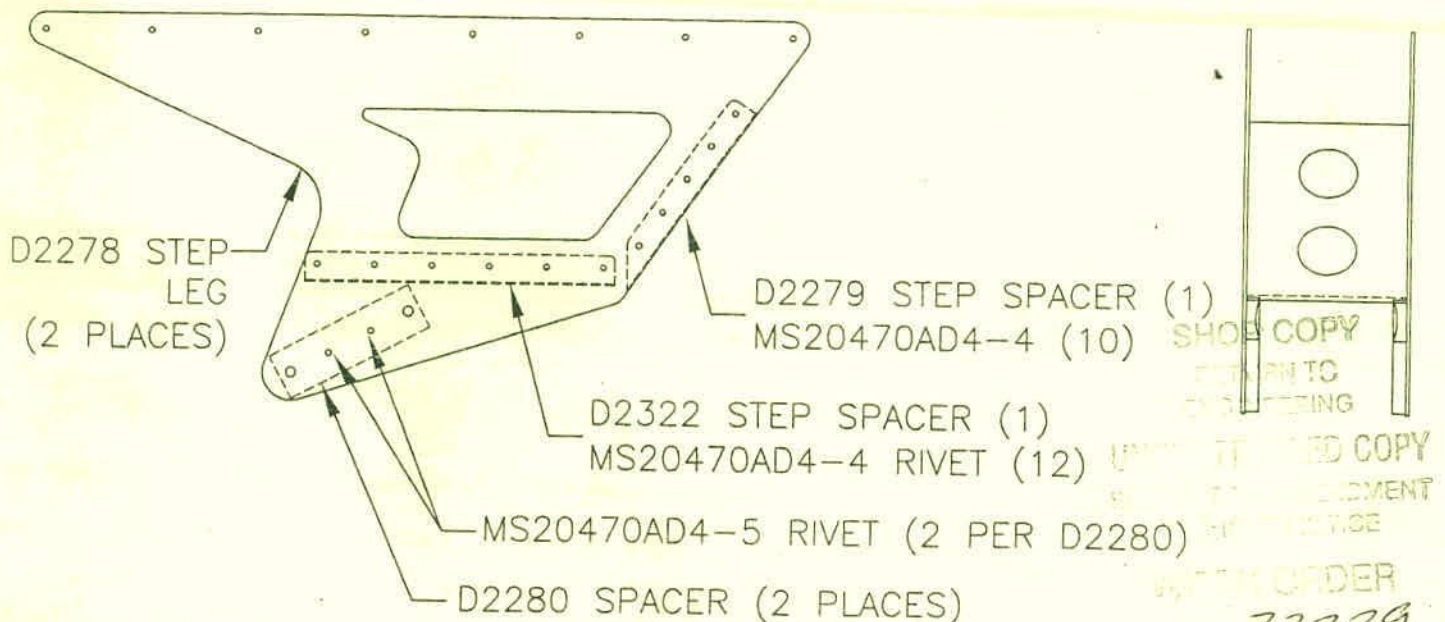
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2582	REV. A SHEET 1 OF 1
DATE 01.10.05		TITLE STEP LEG ASSEMBLY	SCALE 1:5
A	01.10.05	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION
2	D2278	STEP LEG
1	D2279	STEP SPACER
2	D2280	SPACER
1	D2322	STEP SPACER
22	MS20470AD4-4	RIVET
4	MS20470AD4-5	RIVET



D2582

23329
RELEASED
01-10-16 #

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
BW	CP	DRAWING NO.	D2322	REV. C
CHECKED KE	APPROVED [Signature]	TITLE	STEP SPACER	SHEET 1 OF 1
DATE 98.09.29		SCALE	1:2	
A	94.10.14	NEW ISSUE		
C	98.09.29	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER NCR 001		

RELEASED
18.10.08 DS

UNDER REVIEW

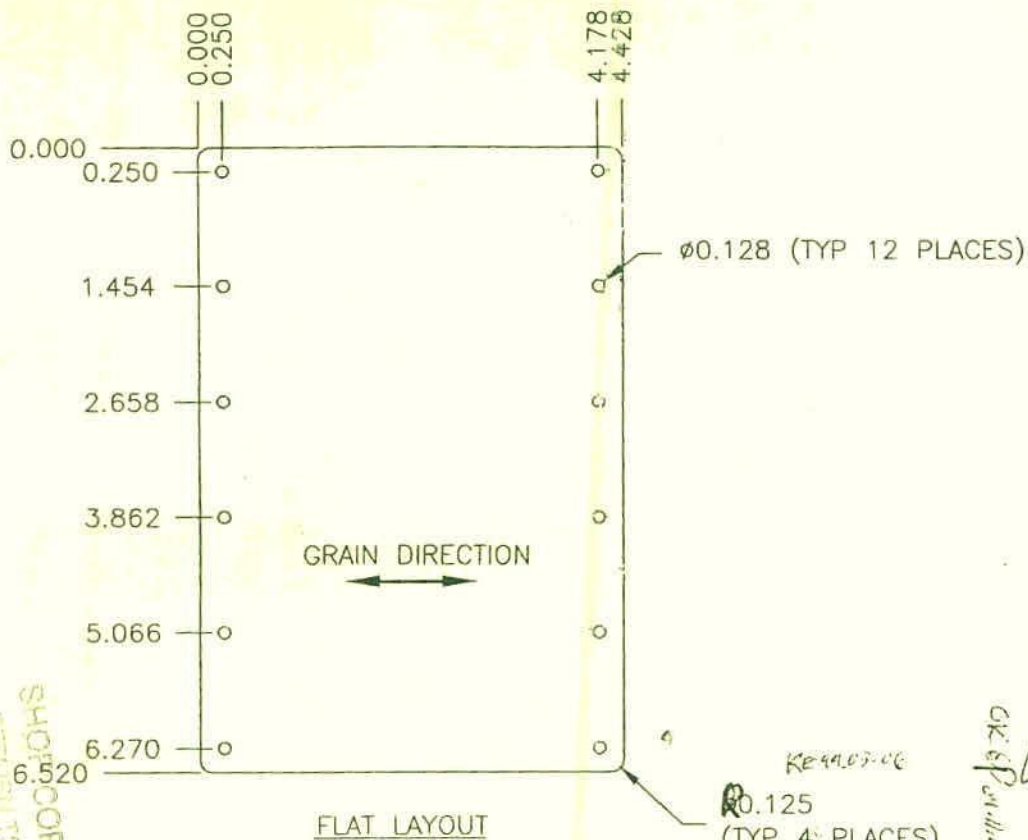
01.07.15 CP

DESIGN OK, BUT CHECK WITH
DTS BEFORE MANUFACTURE

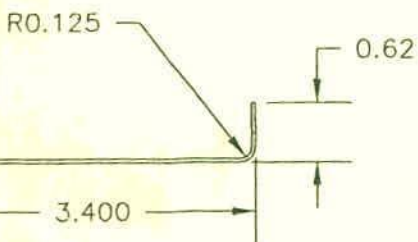
OK CP 01.07.15

KE 98.09.29

R0.125
(TYP 4 PLACES)



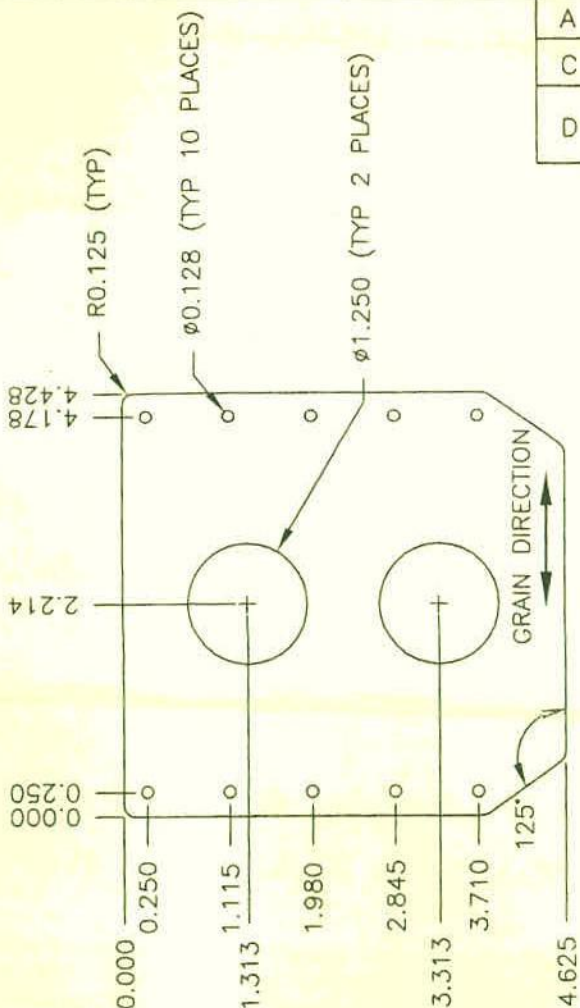
FLAT LAYOUT



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN BW	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RE	APPROVED [Signature]	DRAWING NO. D2279	REV. D SHEET 1 OF 1
DATE 98.10.05	TITLE STEP SPACER		SCALE 1:2
A	94.10.13	NEW ISSUE	
C	94.11.15	0.588 WAS 1.607 AND 3.861 WAS 4.881	
D	98.10.05	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER TSR A912	



FLAT LAYOUT

RELEASED
98.10.08 DS

UNDER REVIEW

DESIGN OK, BUT CHECK WITH
JB BEFORE MANUFACTURE

OK 98.11.09



FLANGE AFTER BENDING
TOWARDS INSIDE OF PART
USING DT8174 (2 PLACES)

0.62

NO. 23329

3.400

R0.125

MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

